

Built per 4

Work Order ID 69476

Wednesday, May 11, 2011 11:52:13 AM



Page 1

Item ID: D2432

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 (24") Bearpaw

Start Date: 5/11/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2432	Rev F3								
120		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per D2432 File								
130		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr								
140		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

~~1311-6-9~~ 1311-6-9

(12)
(13)

~~1311-6-9~~

JK 11-08-17

JK 11-08-17

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69476

Wednesday, May 11, 2011 11:52:14 AM



Page 2

Item ID: D2432

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 (24") Bearpaw

Start Date: 5/11/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

OK 11/08/18

13

1

Quality Control

151

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

11/8/18 [Signature]

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/8/18 [Signature]

Quality Control

11/8/18 [Signature]
(12)

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 11, 2011 11:52:20 AM

Page 1

Work Order ID: 69476

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw



Start Date: 5/11/2011

Required Date: 5/18/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	163.0000	3.7	44.4			



UHMW 1" Black



~~HB 11-5-11~~ HB 11-6-9

Location

Loc Qty

Loc Code

MAT018

163

116554

2

117321

161

~~117321~~
117819

13

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.07 x 45°	✓		Vern JL-3	
B	5.500	+/-0.030	5.505	✓		"	
C	0.200	+/-0.030	.200	✓		"	
D	0.25 x 45°	+/-0.030	.255 x 45°	✓		"	
E	R0.250	+/-0.030	.250	✓		R-G	
F	0.250	+/-0.010	.244	✓		"	
G	0.625	+/-0.030	.618	✓		"	
H	0.375	+/-0.010	.368	✓		"	
I	0.950	+0.030/0.010	.950	✓		"	
J	19.000	+/-0.030	19.00	✓		m-type	
K	3.14	+/-0.030	3.160	✓		"	
L	3.28	+/-0.030	3.300	✓		"	
M	Ø0.260	+0.005/-0.000	.260	✓		"	
N	Ø0.93	+/-0.030	.927	✓		"	
O	0.30	+0.030/-0.000	.315	✓			Vern JL-3
P	23.750	+/-0.030	23.75	✓		m-type	
Q	7.375	+/-0.030	7.377	✓		Vern CMC-02	
R	4.250	+/-0.010	4.250	✓		"	
S	2.000	+/-0.030	2.015	✓		"	
T	9.000	+/-0.010	9.000	✓		Vern CMC-02	
U	9.000	+/-0.010	9.000	✓		"	
V	0.375	+/-0.010	.378	✓		"	

Measured by: SL	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11-08-17	Date: 11/08/18	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF [Signature]	[Signature]

Dart Aerospace Ltd

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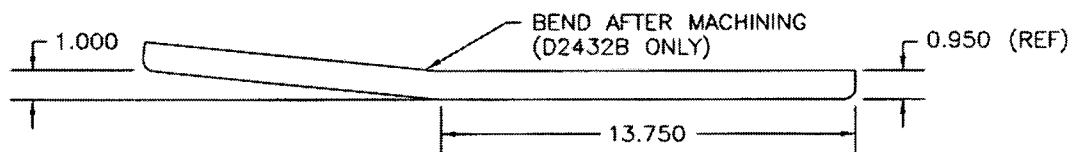
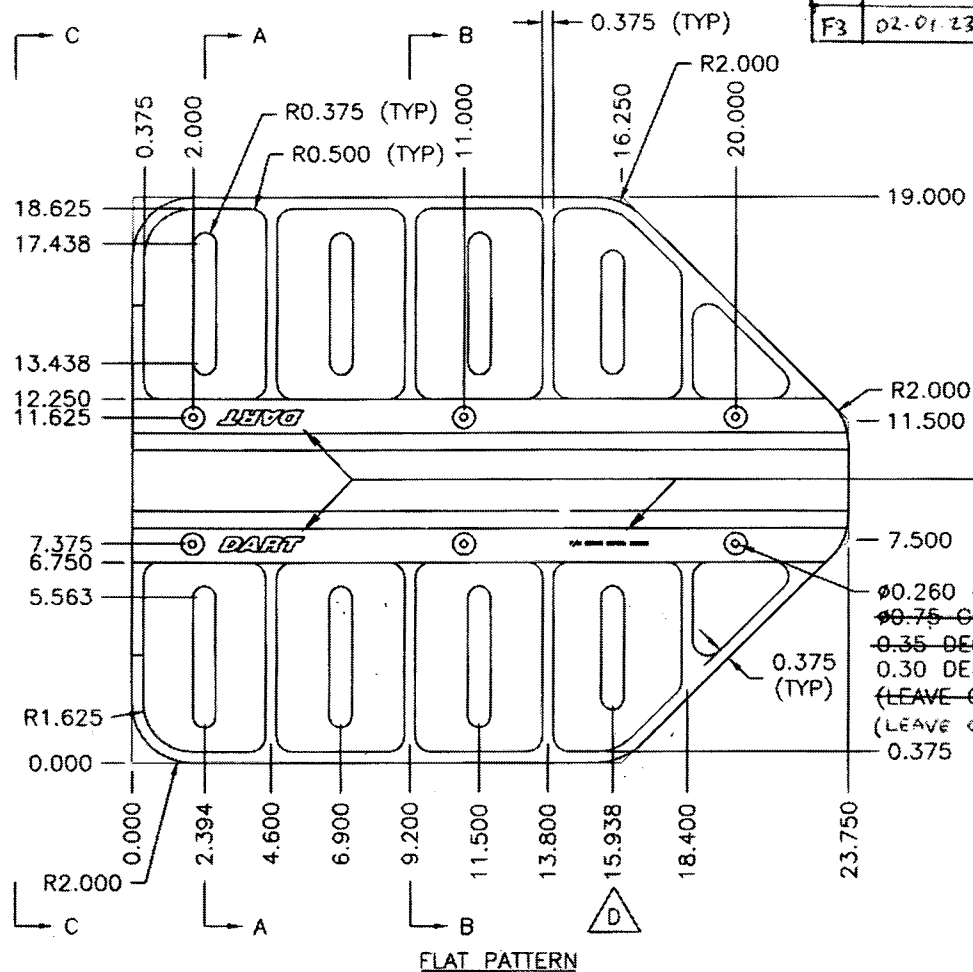
NOTE: Date & initial all entries

F1	99.03.03	ADD DEO 9143
F2	01.03.28	$\phi 0.93$ WAS $\phi 0.75$ RF
F3	02.01.23	CLARIFY BORE DIMS RF

RELEASED
98.06.17 KE

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT: D2432
WORK ORDER
NO. 69476
11/1051



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

EFFECTIVE	DEOS
9143	

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
KE	KE	
CHECKED	APPROVED	DRAWING NO.
MM		D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
		SCALE
		1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

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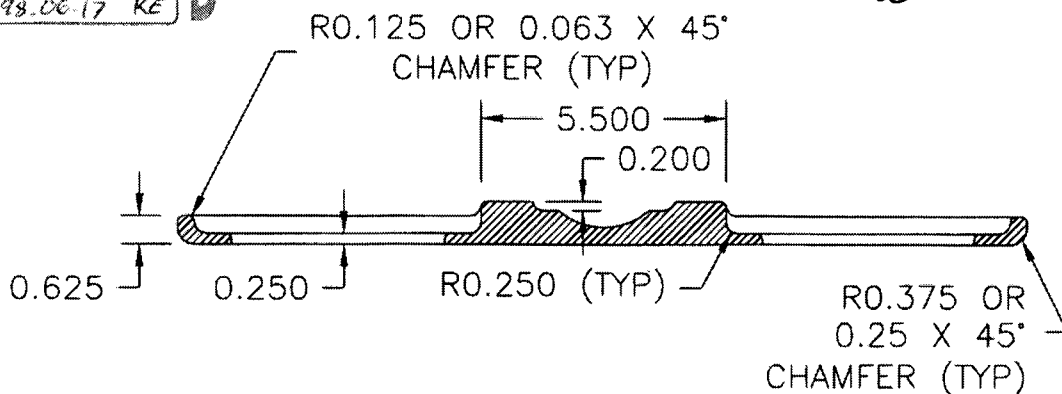
NOTE: Date & initial all entries



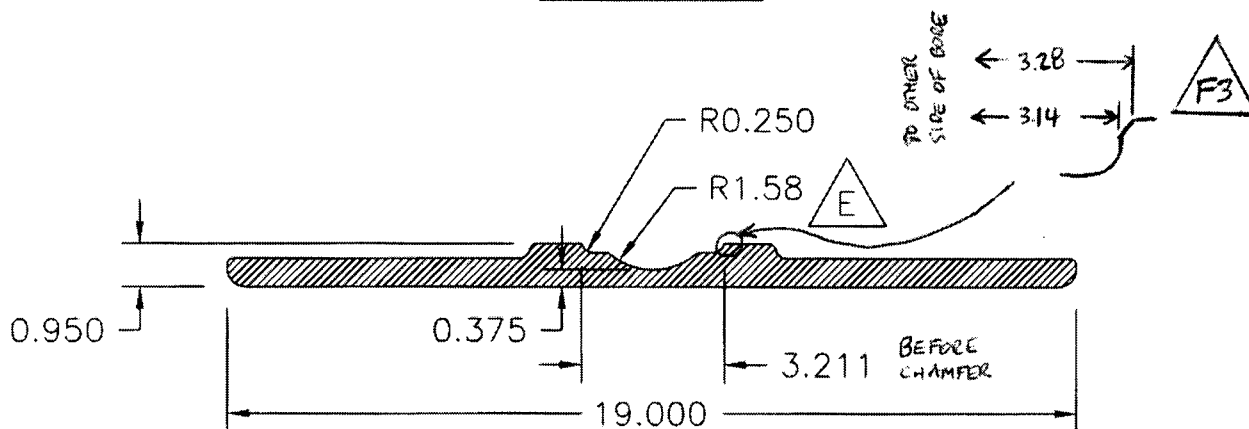
DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ME</i>	APPROVED <i>KE</i>	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED
98.06.17 KE

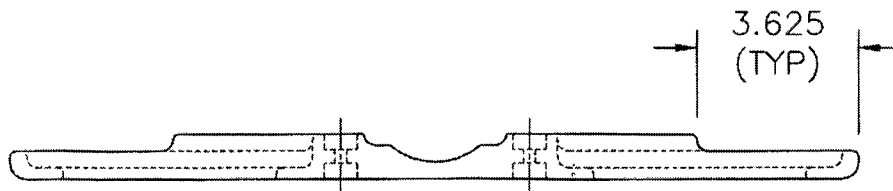
u1069474



SECTION A-A



SECTION B-B



SECTION C-C

W/O:		WORK ORDER CHANGES					
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